

Date: Wednesday, 04/06/2008 2:23:49 PM
User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET |
| Job Number | : 39701 | | |
| Estimate Number | : 11144 | | |
| P.O. Number | : | Part Number | : D32075 |
| This Issue | : 04/06/2008 S.O. No. : | Drawing Number | : D3207 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 34217 | Material | : |
| Written By | : <u> </u> | Due Date | : 05/06/2008 Qty: 4 Um: Each |
| Checked & Approved By | : <u> </u> | | |
| Comment | : Est A 04.06.09 New issue KJ/RF | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S125 | 6061-T6 .125 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0773 sf(s)/Unit Total: 0.3091 sf(s)
6061-T6 .125 Sheet
Material: 6061-T6 (QQ-A-250/11) 0.125" thick
(M6061T6S.125)
Identify for D3207-5
Batch: 105646 HB 8-6-5

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3207
Dwg Rev: A
Prog Rev: A

HB 8-6-5

(S)

2-Deburr if necessary

SB 08/06/05

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-6-5

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

✓

S 08/06/05 (S)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
Form as per Dwg D3207

SB 08/06/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/06/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 04/06/2008 2:23:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39701

Part Number: D32075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/05 x5

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RL/ FL 08/06/05

(5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:25

OVEN TEMPERATURE:

320°

FINISH TIME:

7:55

FL 08/06/06

(5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-1

08/06/06

(5X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/6/6

30

(5X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/06/06

(3)

Job Completion



MF 08-06-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

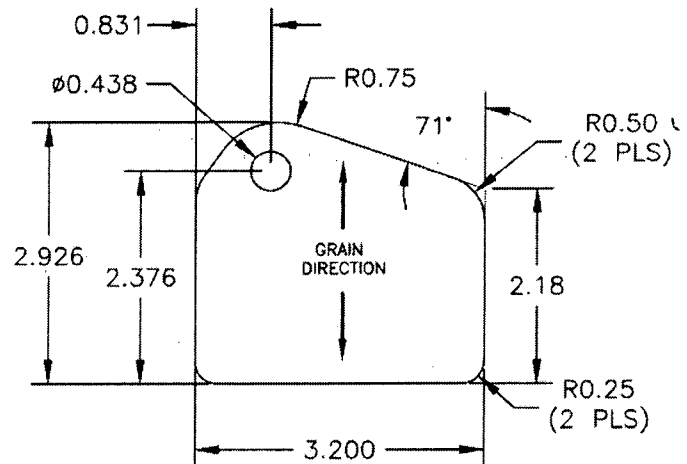
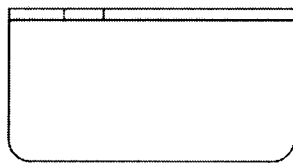
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

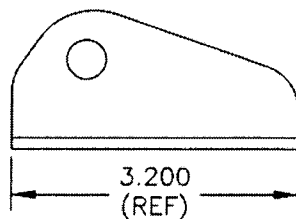


| | | | |
|------------------|---------------|---|------------------------|
| DESIGN H | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3207 | REV. A SHEET 3 OF 3 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |

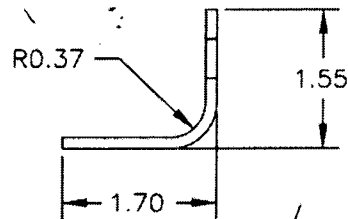
RELEASED
04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL



w/o 39701

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

